

Work Order ID 96333

Tuesday, March 05, 2013 12:53:39 PM

~~PRELIMINARY ISSUE~~

96333

DUPLICATE
can't find original
Page 1

Item ID: D3315-2

Revision ID: U/R

Item Name: Wearplate

Start Date: 1/24/2013 Start Qty: 24.00

Required Date: 1/24/2013 Req'd Qty: 24.00

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

WUR

Date:

13-3-5

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Pc2 C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Pc2

Prog Rev:

Pc2

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

29

*13-03-05
For Jessl*

29

*13-03-05
For Jessl*

Work Order ID 96333

96333

Page 2

Tuesday, March 05, 2013 12:53:39 PM

Item ID: D3315-2

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Stop

NS2

Item Name: Wearplate

Start Date: 1/24/2013 Start Qty: 24.00

24

Cust Item ID:

Required Date: 1/24/2013 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: C
2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: C

21

SB 13/03/05

Work Order ID 96333

Tuesday, March 05, 2013 12:53:39 PM

96333

Page 3

Item ID: D3315-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Wearplate
Start Date: 1/24/2013 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 1/24/2013 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC6- Inspect dimensions to drawing 0.00

150

QC

Memo

Quality Control

160 0.00

160

Large Fab

Large Fab

Memo

Large Fab

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev: C

7560 Hardcoat Rod

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

Quality Control

8/13/15

21 ME / 13-03-05

8/13/15

Work Order ID 96333

Tuesday, March 05, 2013 12:53:39 PM

96333

Page 4

Item ID: D3315-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Wearplate
 Start Date: 1/24/2013 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 1/24/2013 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/3/3/5					
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>320° 11:00am</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>11:30am</u>	0.00 0.00							21 x 4 Jll 12/6>/65
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		8/3/3/5					

Work Order ID 96333***96333***

Page 5

Item ID: D3315-2

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Wearplate

Stop ***NS2***

Start Date: 1/24/2013 Start Qty: 24.00

24

Cust Item ID:

Required Date: 1/24/2013 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Packaging

Memo

ST 000

0.00

Packaging

13/01/31 21

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13/3/5

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

13/3/5

MRF

13-3-5

Work Order Summary

Tuesday, March 05, 2013 12:51:51 PM

Page 1 of 2

Criteria : Work Order ID: 96333 Item ID: D3315-2 Product Family SMALL FAB
 Work Order Start Dates 1/24/2013 to 1/24/2013 11:59:59 PM Work Order Required Dates 1/24/2013 to 1/24/2013 11:59:59 PM
 All References
 Work Order Status Costed

Work Order ID	96333	Required Qty	24.0000	Status Code	Costed
Item ID	D3315-2	Accepted Qty	21.0000	Scrap Qty	0.0000
Item Name	Wearplate				
Current Acct Value	\$96.114				
Start Date	1/24/2013	Required Date	1/24/2013	Completed Date	2/20/2013 11:32:49 AM

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$57.872	\$2.756	\$2.947	\$0.191	6.48%
Labor	\$551.466	\$26.260	\$35.103	\$8.843	25.19%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,251.079	\$59.575	\$76.883	\$17.308	22.51%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,860.417	\$88.591	\$114.933	\$26.341	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M1010S16GA					
1010/1025 sheet 16GA	40.6800		2/20/2013	32.0000	\$57.872
Total Matl Amts:					\$57.872

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01	2/7/2013											
140			0.00	0.00	0.62	0.62	1.00	\$0.000	\$12.388	\$31.439	\$0.000	\$43.826
140			0.00	0.00	0.55	0.55	1.00	\$0.000	\$11.005	\$27.931	\$0.000	\$38.936
Total:			0.00	0.00	1.18	1.18	2.00	\$0.000	\$23.393	\$59.370	\$0.000	\$82.762

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
cui101	2/14/2013											
160			0.00	0.00	7.56	7.56	1.00	\$0.000	\$154.122	\$343.450	\$0.000	\$497.572

2/15/2013											
160		0.00	0.00	3.93	3.93	1.00	\$0.000	\$80.166	\$178.644	\$0.000	\$258.810
2/19/2013											
160		0.00	0.00	5.89	5.89	1.00	\$0.000	\$120.172	\$267.796	\$0.000	\$387.968
160		0.00	0.00	1.51	1.51	1.00	\$0.000	\$30.753	\$68.531	\$0.000	\$99.284
LARO01											
2/19/2013											
160		0.00	0.00	4.22	4.22	1.00	\$0.000	\$86.082	\$191.828	\$0.000	\$277.910
Total:		0.00	0.00	23.10	23.10	5.00	\$0.000	\$471.295	\$1,050.249	\$0.000	\$1,521.544

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
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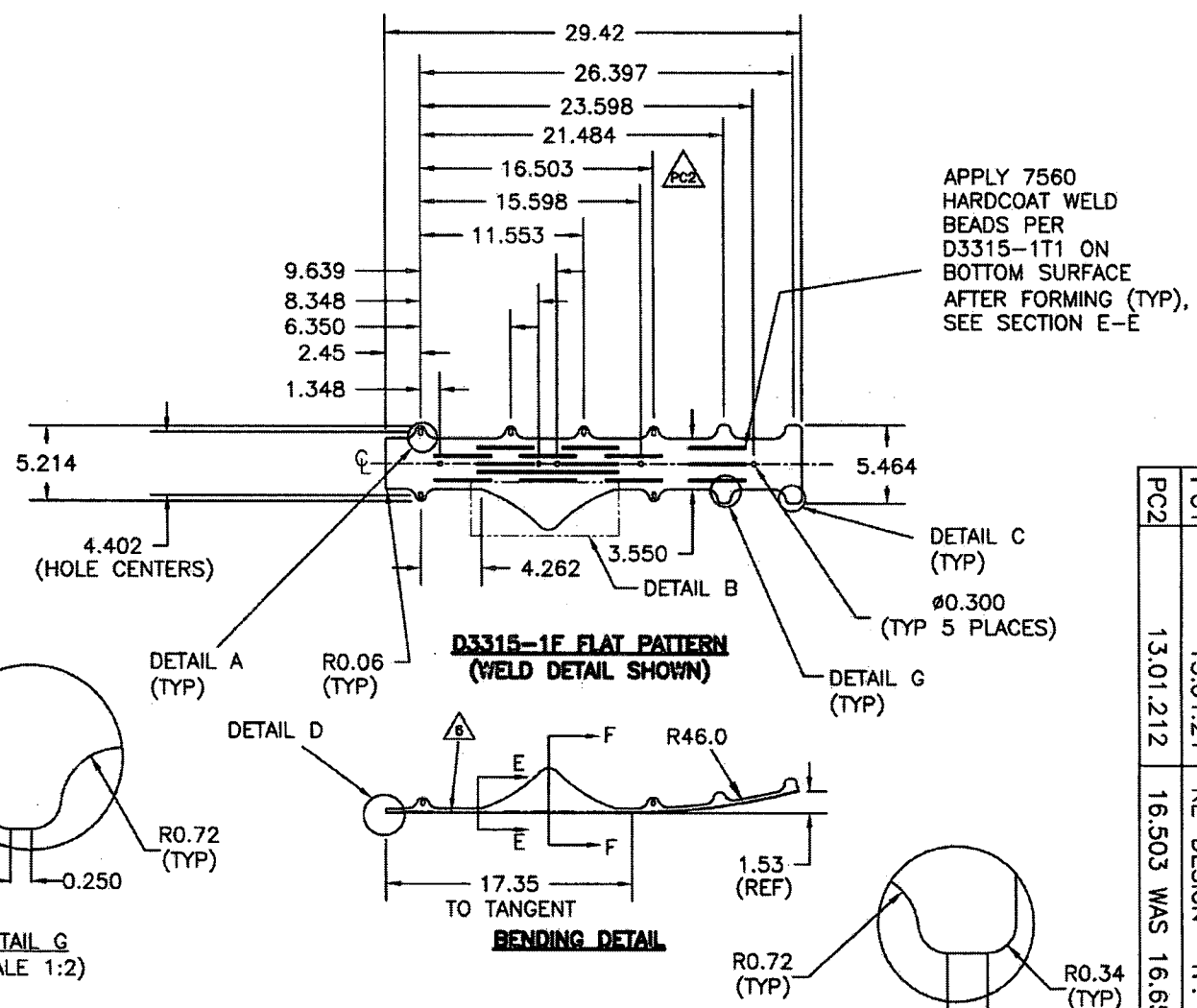
LAUG01											
2/20/2013											
190		0.00	0.00	0.33	0.33	1.00	\$0.000	\$6.214	\$13.131	\$0.000	\$19.344
Total:		0.00	0.00	0.33	0.33	1.00	\$0.000	\$6.214	\$13.131	\$0.000	\$19.344

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
-------------	-------------	------------	-------------	--------------------	-------------	--------------------	------------	--------------	--------------	-----------------	-----------------	---------------

macl01											
1/29/2013											
100		0.00	0.00	2.54	2.54	1.00	\$0.000	\$50.564	\$128.330	\$0.000	\$178.895
Total:		0.00	0.00	2.54	2.54	1.00	\$0.000	\$50.564	\$128.330	\$0.000	\$178.895

13.01.22

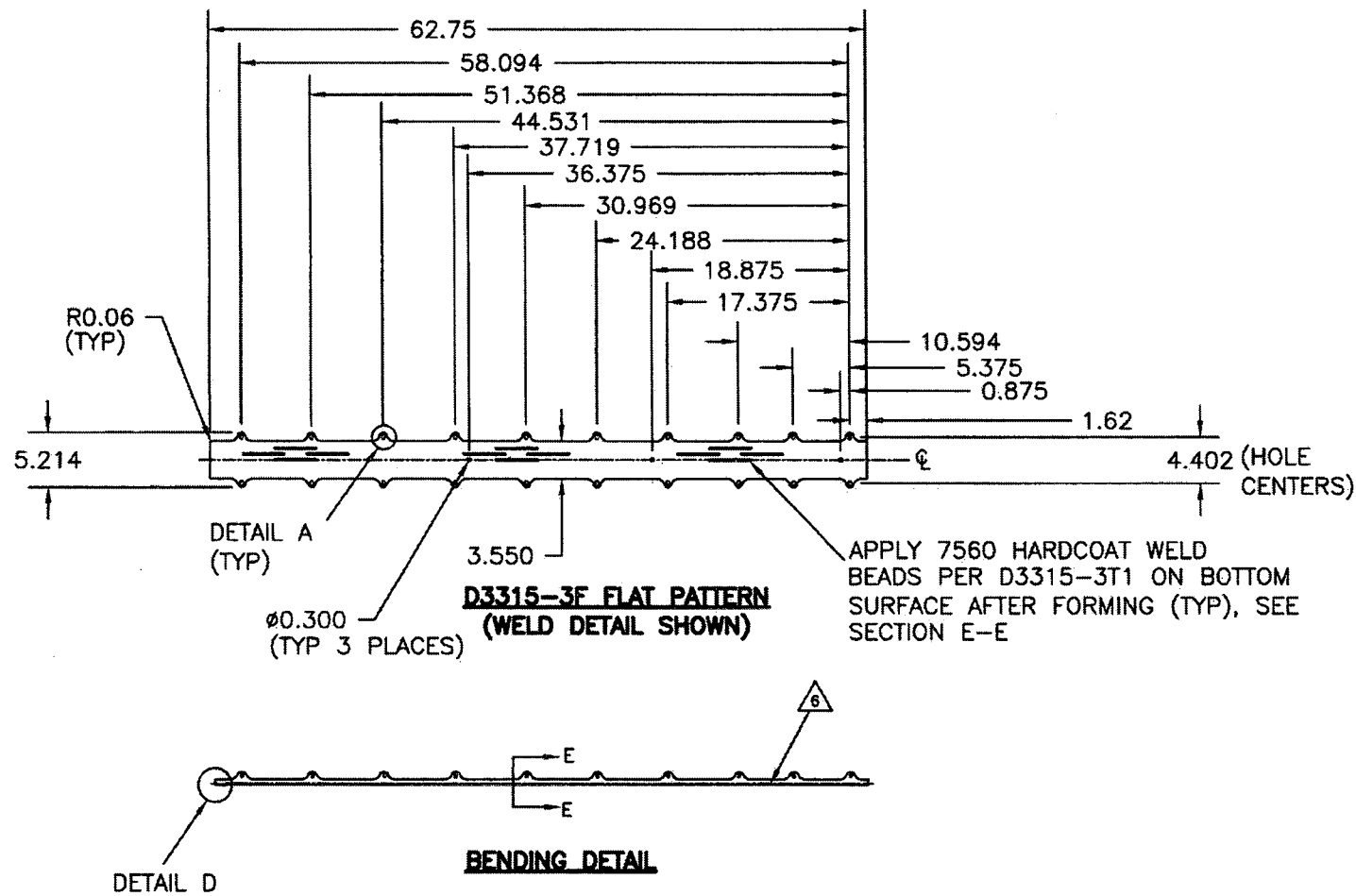


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D3315
DATE	TITLE	WEARPLATE
13.01.22	NEW ISSUE	SCALE 1:12
A	04.09.10	REV. PC2
B	06.01.31	SHEET 1 OF 4
PC1	13.01.21	RE-DESIGN -1F. REF: NCR12-1750
PC2	13.01.212	16.503 WAS 16.653

- D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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13.01.22



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

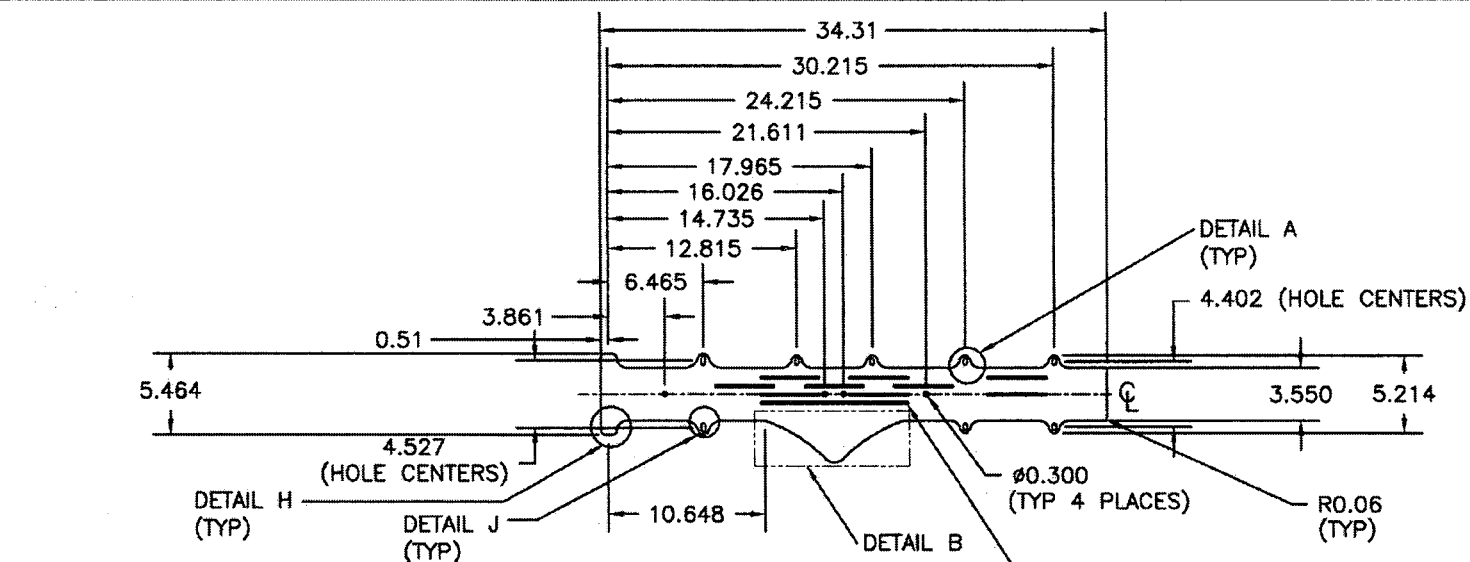
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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DATE	DRAWING NO.	REV. PG2
13.01.22	D3315	SHEET 2 OF 4
	TITLE	SCALE
	WEARPLATE	1:16

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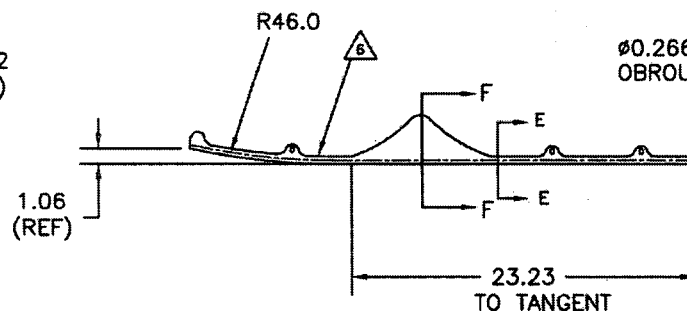
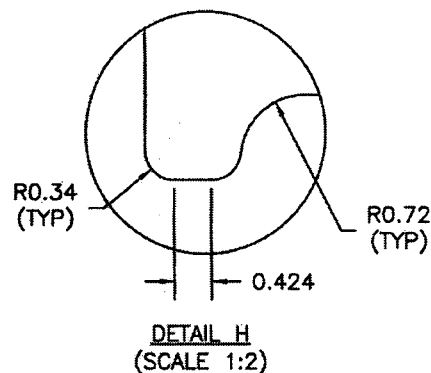
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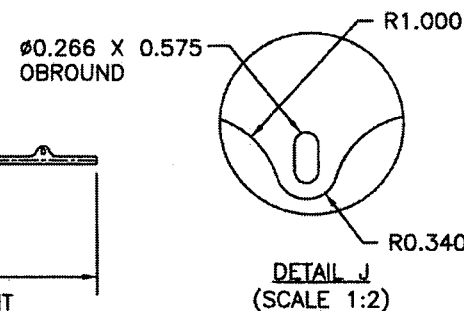


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

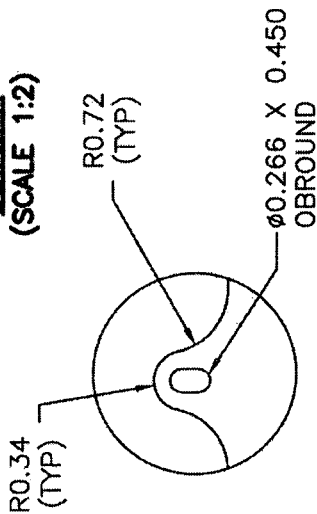
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. PC2
13.01.22	D3315	SHEET 3 OF 4
	TITLE	SCALE
	WEARPLATE	1:12

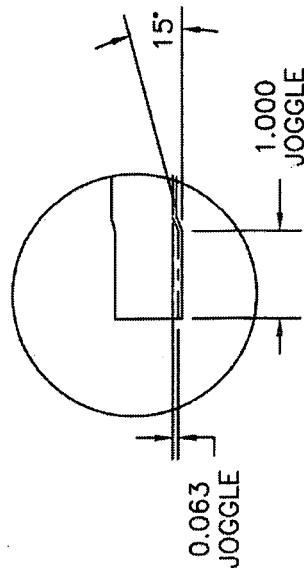
PRELIMINARY ISSUE
13.01.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3315	REV. PC2 SHEET 4 OF 4
DATE 13.01.22		TITLE WEARPLATE	SCALE NTS

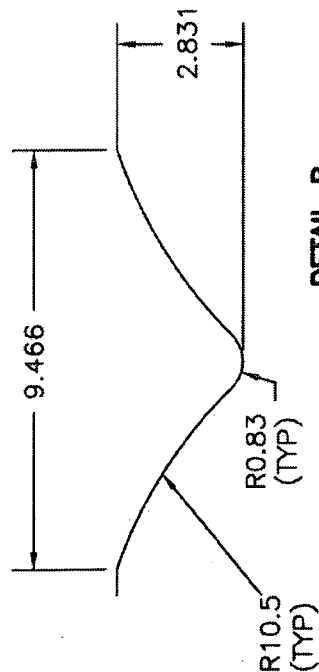
DETAIL A
(SCALE 1:2)



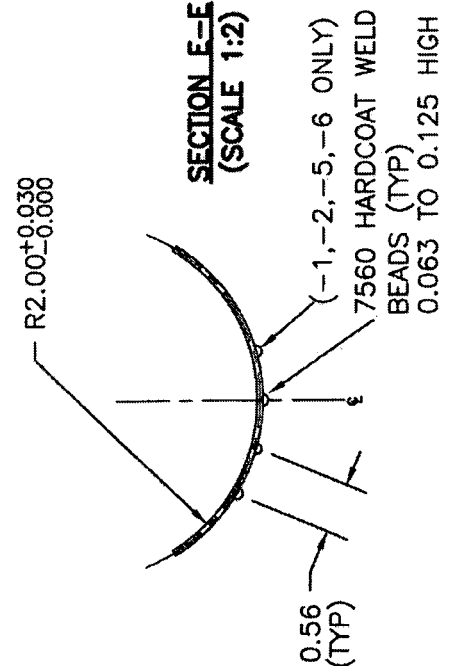
DETAIL D
(SCALE 1:2)



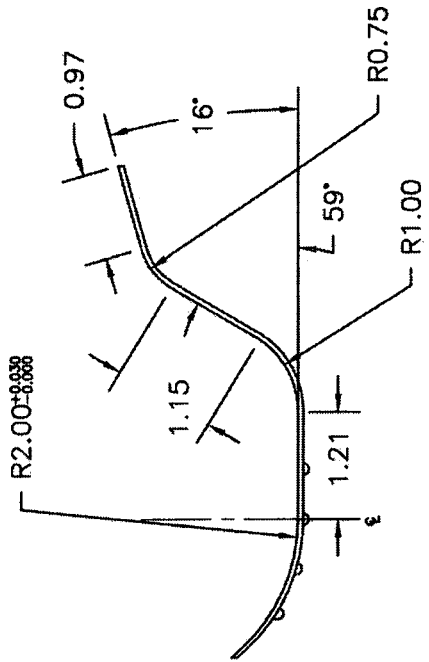
DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)

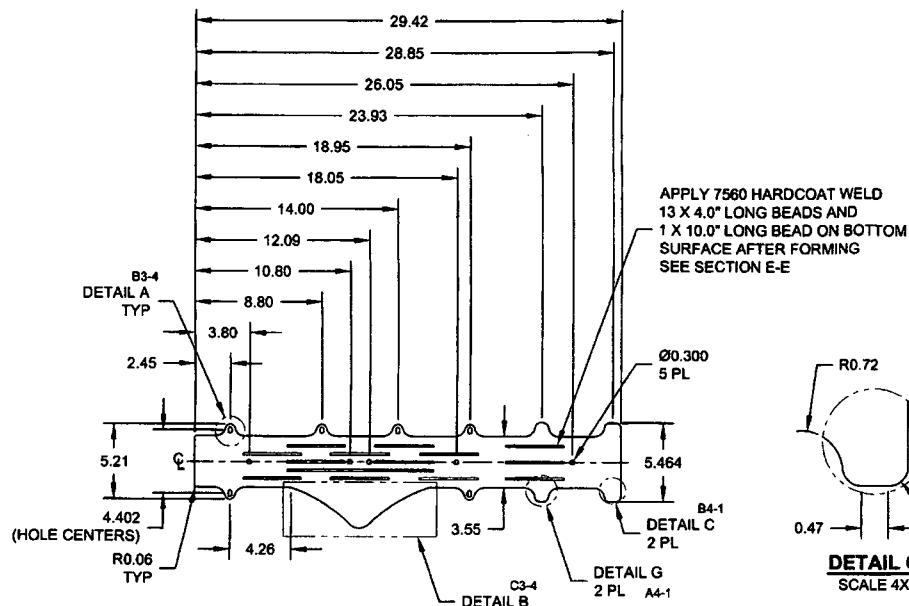


SECTION F-F
(SCALE 1:2)

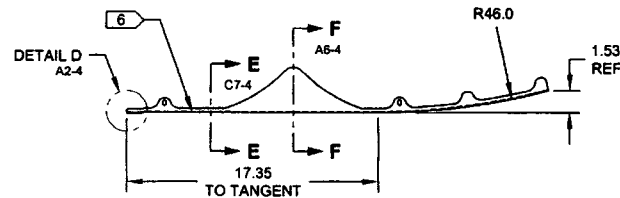
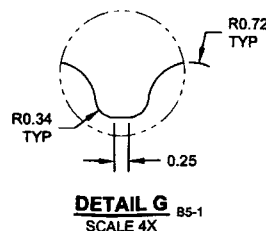
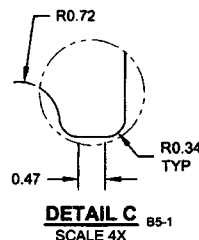


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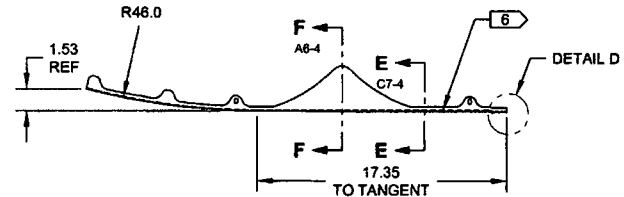


D3315-1F FLAT PATTERN
(D3315-1 SHOWN, D3315-2 OPPOSITE)



D3315-1 WEARPLATE
MAKE FROM D3315-1F

RELEASED
2013-02-14



D3315-2 WEARPLATE
MAKE FROM D3315-1F

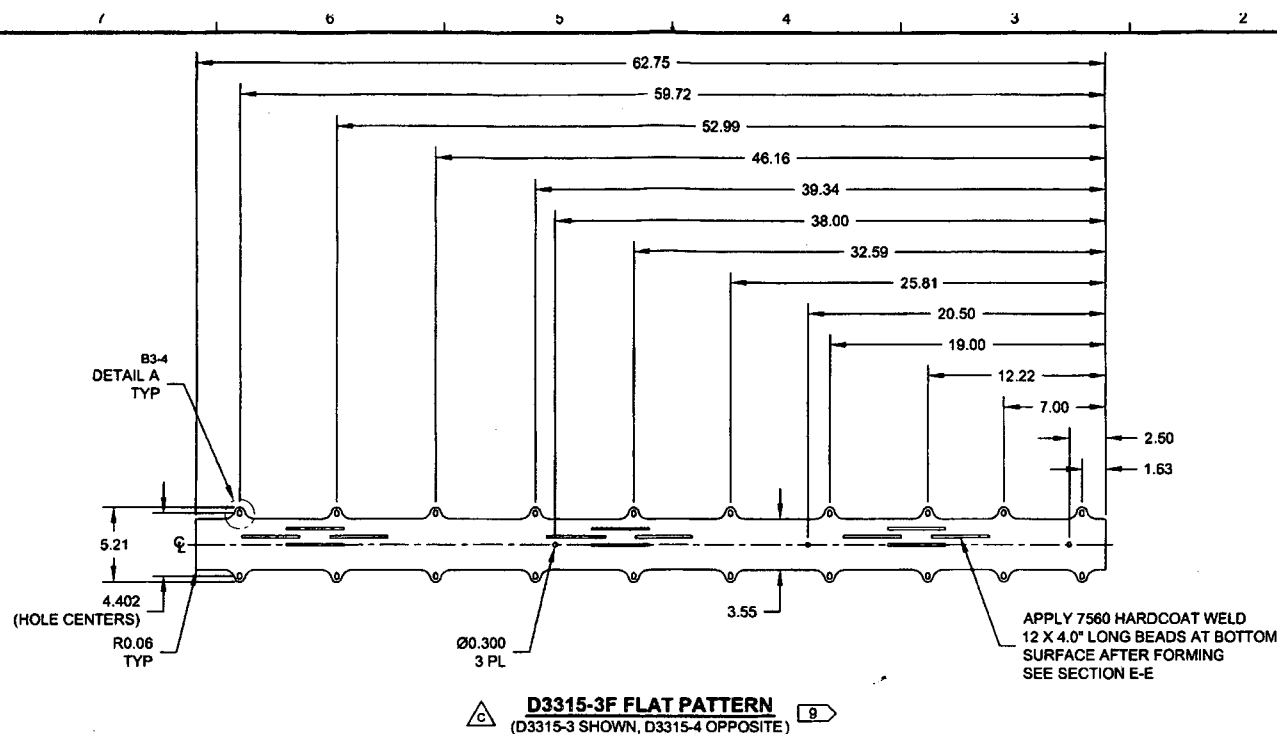
D3315-1/-2-1F NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 16 GAUGE (0.060 THICK) REF. DART SPEC. M1010GA16
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 2.15 lbs
- 8) WELDING: PER DART QSI 004
- 9) WATERJET PROGRAMMING: PER D3315-1F_REV.C.DXF

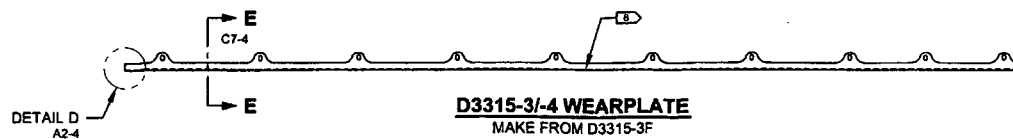
C	UPDATED DWG TO CURRENT STD; RE-DESIGNED -1F; CORRECTED DRAFTING ERRORS ON -5F; DIMS REVIEWED ON 1/F/-3F/-5F. REF: NCR12-1750.	MB	13.01.22
B	UPDATE DIMENSIONS	PH	08.01.31
A	NEW ISSUE	PH	04.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	B		
CHECKED	CP		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	13.01.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3315	REV. C SHEET 1 OF 4
TITLE WEARPLATE	SCALE NTS

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D3315-3F FLAT PATTERN
(D3315-3 SHOWN, D3315-4 OPPOSITE)



D3315-3/-4 WEARPLATE
MAKE FROM D3315-3F

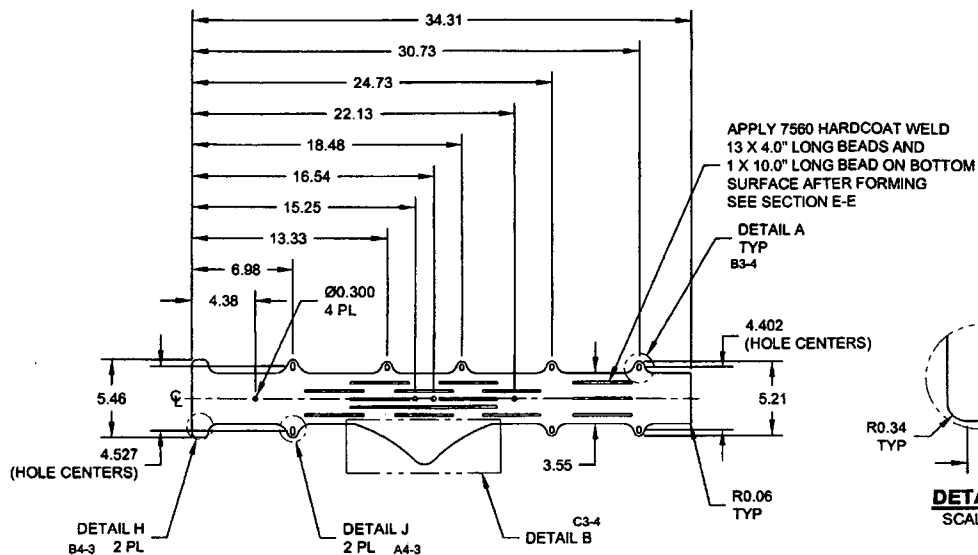
D3315-3/-4-3F NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 16 GAUGE (0.060 THICK) REF. DART SPEC. M1010GA16
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 4.15 lbs
- 8) WELDING: PER DART QSI 004
- 9) WATERJET PROGRAMMING: PER D3315-3F_REV.C.DXF

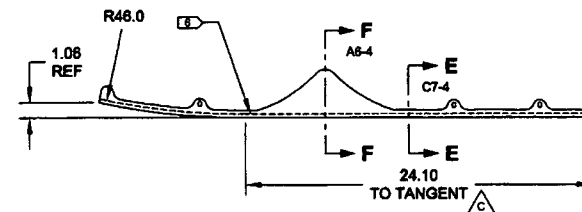
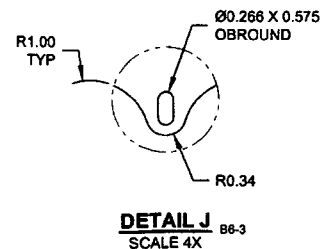
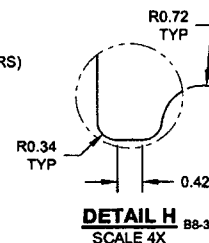
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3315 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	13.01.22	

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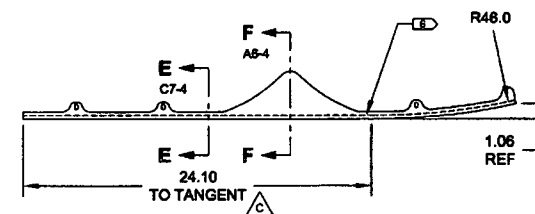
RELEASE
2013-02-16



D3315-5F FLAT PATTERN
(D3315-5 SHOWN, D3315-6 OPPOSITE)



D3315-5 WEARPLATE
MAKE FROM D3315-5F



D3315-6 WEARPLATE
MAKE FROM D3315-5F

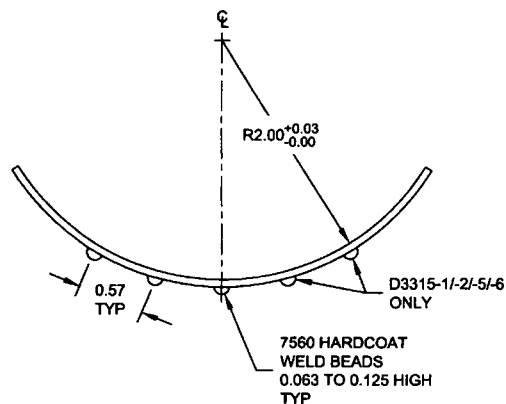
RELEASED
2013-02-14

D3315-5/-6/-5F NOTES:

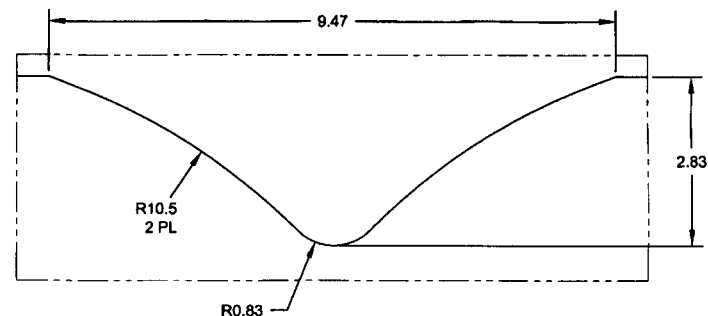
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 16 GAUGE (0.060 THICK) REF. DART SPEC. M1010GA16
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 2.15 lbs
- 8) WELDING: PER DART QSI 004
- 9) WATERJET PROGRAMMING: PER D3315-5F_REV.C.DXF

DESIGN	PM	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO.	REV. C
MFG. APPR.	M	D3315	SHEET 3 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	WEARPLATE	NTS
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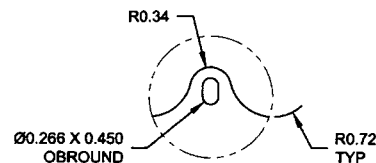
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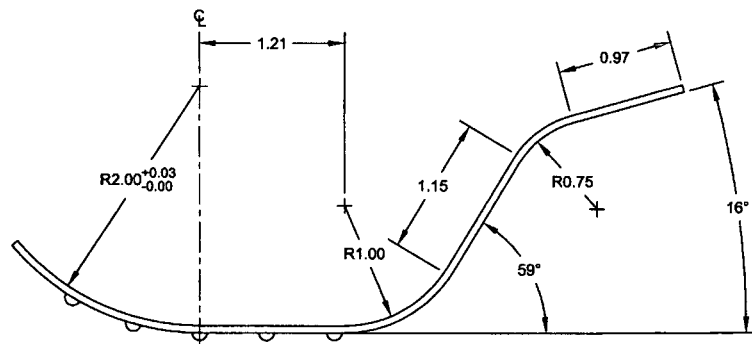
DETAIL E
SCALE 8X
B2-1
D3-1
B6-2
B2-3
D1-3



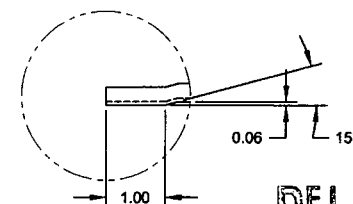
DETAIL B
SCALE 4X
B6-1
B6-3



DETAIL A
SCALE 4X
C8-1
C7-2
C5-3



DETAIL F
SCALE 8X
C2-1
D2-1
C2-3
D2-3



DETAIL D: JOGGLE
SCALE 4X
D3-1
B7-2

RELEASED
2013-02-14

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3315	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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8 7 6 5 4 3 2 1